

Work Order ID 64599

December 9, 2010 8:57:39 AM



Page 1

Item ID: D3188-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD BODY RH

Start Date: 12/09/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/07/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/12/09 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3188 | Rev F | | | | | | | | |

100

0.00



PURCHASING

Purchasing

Memo

0.00

Issue P/O: 13107

Description: D3188-2MBODY

SHIP: QTY (8) D2213 Spacers

~~Ship to Delastek (1) D0600-XXX label~~ CZ 10/12/09Batch: 59792 As per David S.

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

CZ 10/12/09 ①

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

CZ 10/12/09 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 64599

December 9, 2010 8:57:39 AM

Page 2

Item ID: D3188-2M

Accept

Revision ID:

Item Name: SPACEPOD BODY RH

Start Date: 12/09/10 Start Qty: 1.00

Required Date: 1/07/11 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #
Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check for void spot and pins.

8/10/10

70

130

Identify as per dwg & Stock Location: *composites*

0.00



Packaging

Memo

0.00

Packaging

85 11-02-02

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/03 AJ
mf
11-02-03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

December 9, 2010 8:57:38 AM

Page 1

Work Order ID: 64599

Parent Item: D3188-2M

Parent Item Name: SPACEPOD BODY RH



Start Date: 12/09/10

Required Date: 1/07/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
IPP rev B rev D dwg 07.03.07 ec
IPP rev C rev E dwg 07.04.16 EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2213  Insert | | Manufactured | No | | | 100 | Each | 211.0000 | 8 | 8 | | | |
| | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST008 | | 211 | | | | | | | |
| | | | | 30107 | | 35 | | | | | | | |
| | | | | 30809 | | 176 | | | | | | | |
| D3188-2P  Spacepod Body | | Purchased | No | | | 110 | Each | 0.0000 | 1 | 1 | | | |
| | | | | | | | | | | | | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SHEDULE:

| PART | LAYUP | TRIM AND DRILL |
|----------------|--------|----------------|
| D3188-1M/-1/-5 | DT8003 | DT8501 |
| D3188-2M/-2/-6 | DT8004 | DT8502 |
| D3188-3M/-3/-7 | DT8500 | DT8501 |

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

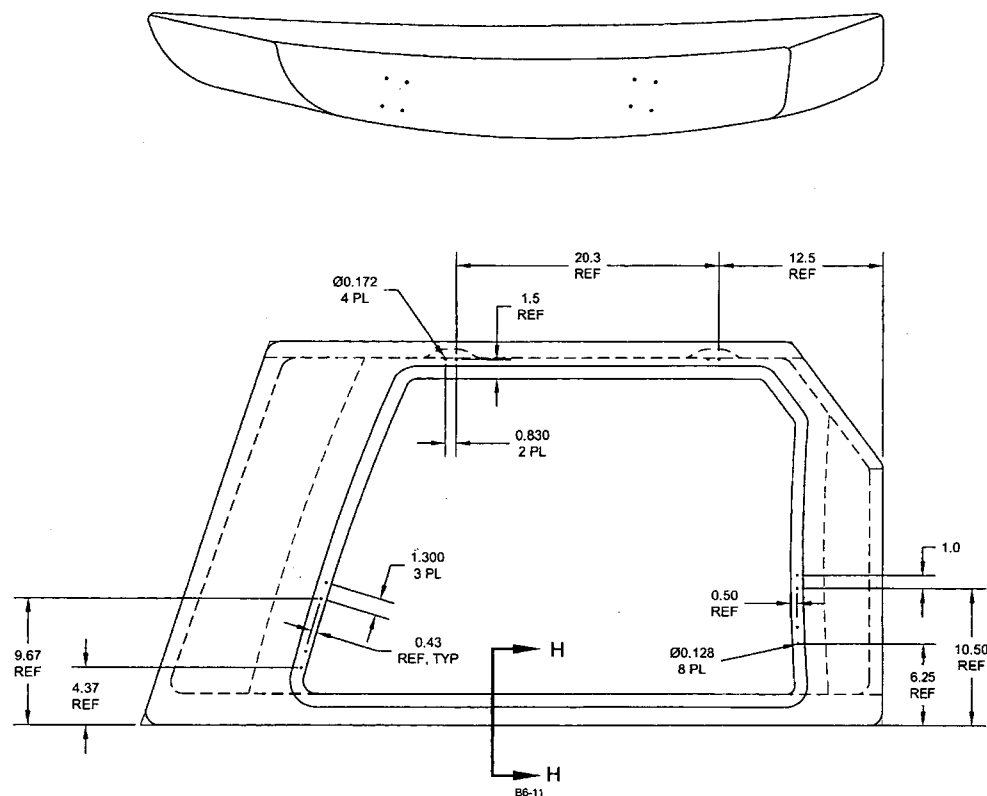
8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

C210112109
W10: 64599

RELEASED
2009-10-20

| | | | |
|------------|--|--|---------------|
| F | REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11) | RF | 09.07.13 |
| E | ADD HYSOL FIBER OPTION ON SHEET 11 | CB | 07.04.02 |
| D | UPDATE DIMENSIONS | LE | 07.02.22 |
| C | REMOVED D0600-XXX LABELS | LE | 06.12.13 |
| B | UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7 | CB | 06.10.06 |
| A | NEW ISSUE | CP | 03.04.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | # | DRAWING NO. | REV. F |
| MFG. APPR. | # | D3188 | SHEET 1 OF 11 |
| APPROVED | # | TITLE | SCALE |
| DE APPR. | # | SPACEPOD BODY | NTS |
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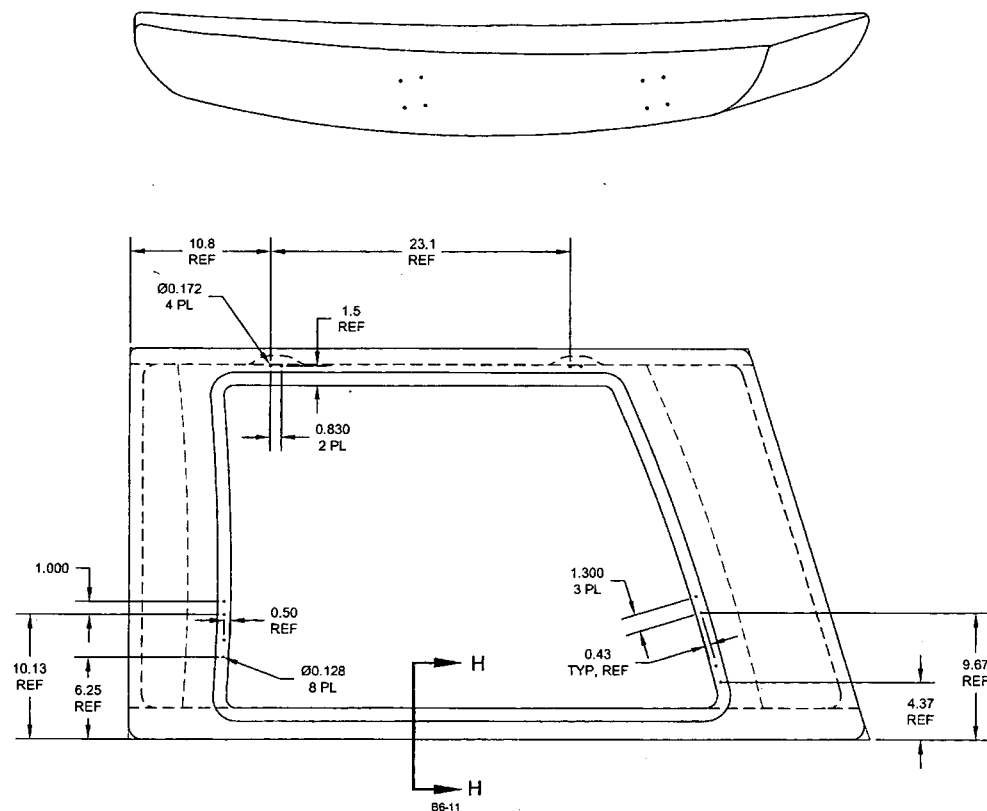
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

| | | | |
|--|---------------|--|---------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 2 OF 11 |
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2009-10-20



D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

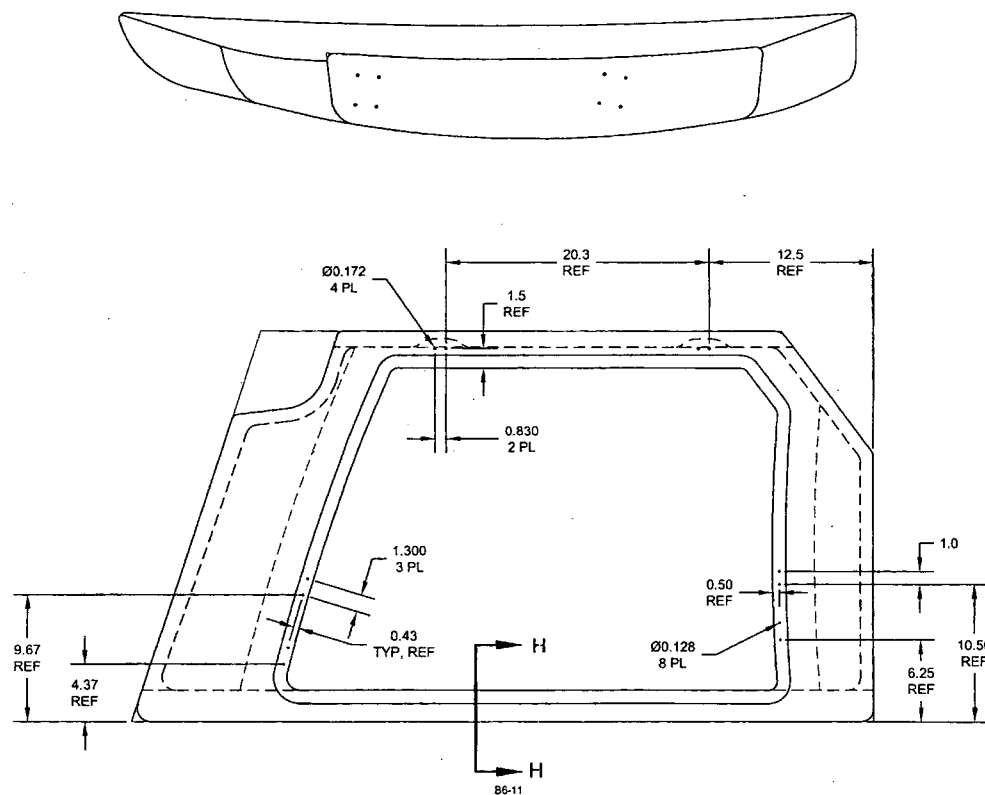
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

W10:67597

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2009-10-20
MP

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| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 3 OF 11 |
| APPROVED | RF | TITLE | SCALE |
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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

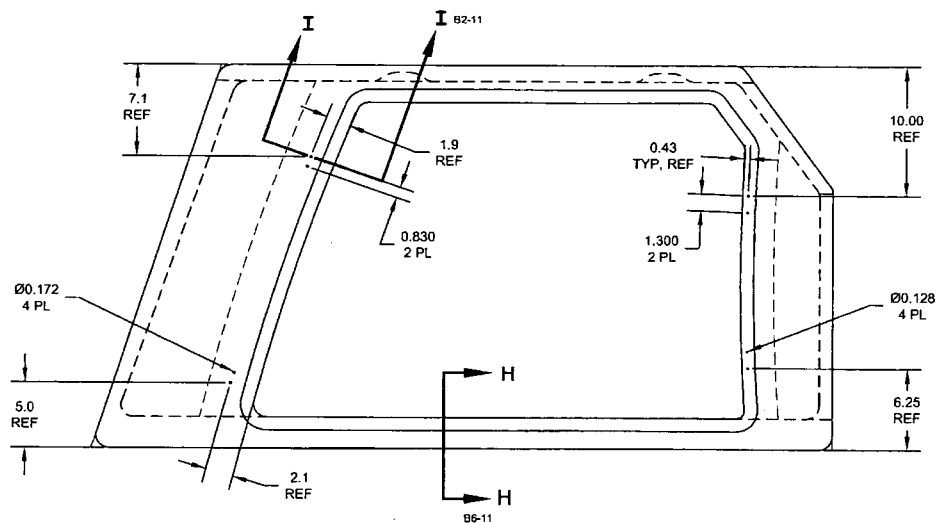
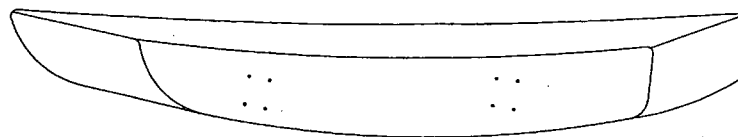
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

W10: 64599

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2009-10-20

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|--|---------------|--|---------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 4 OF 11 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SPACEPOD BODY | NTS |
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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

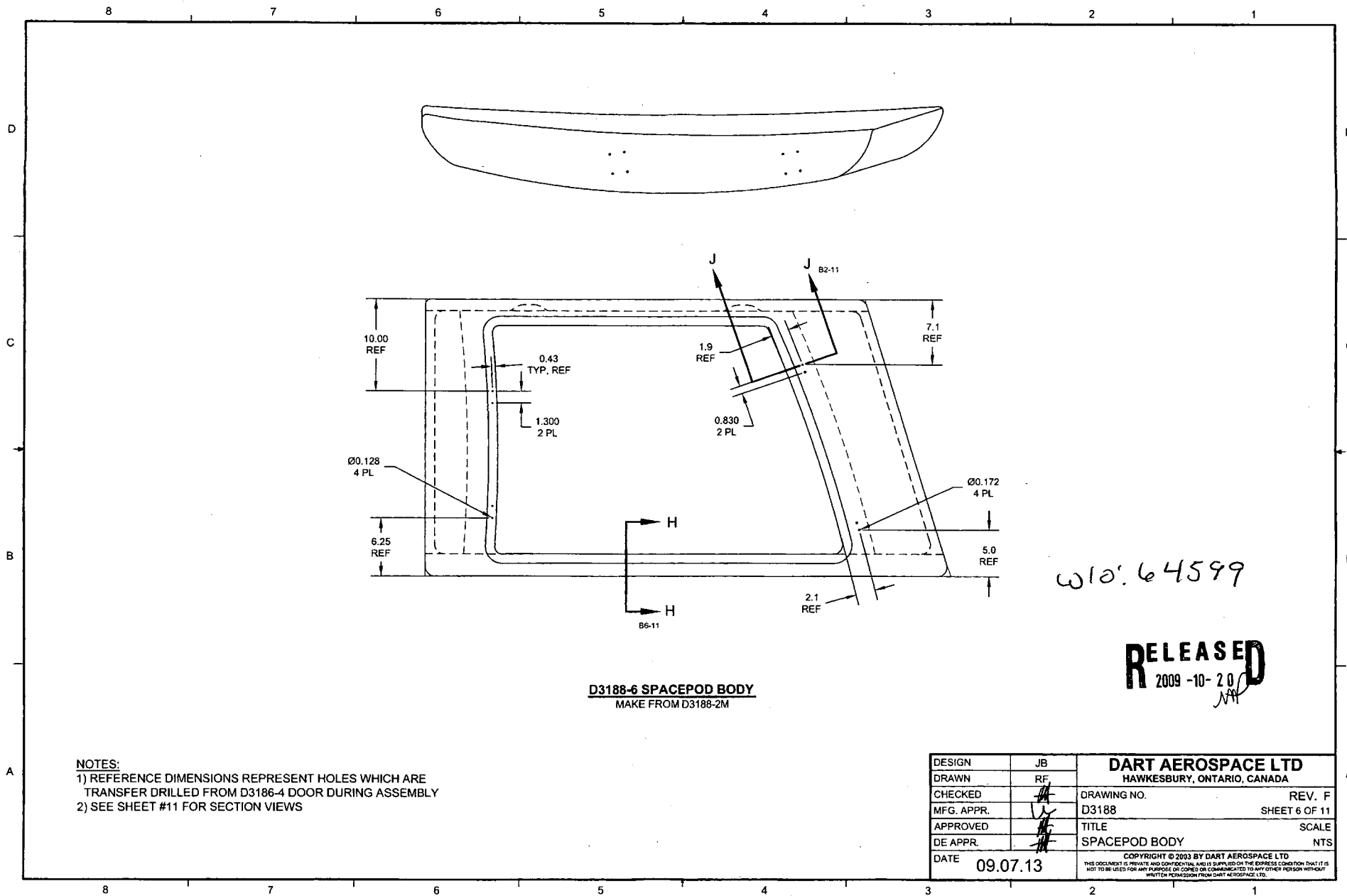
NOTES:

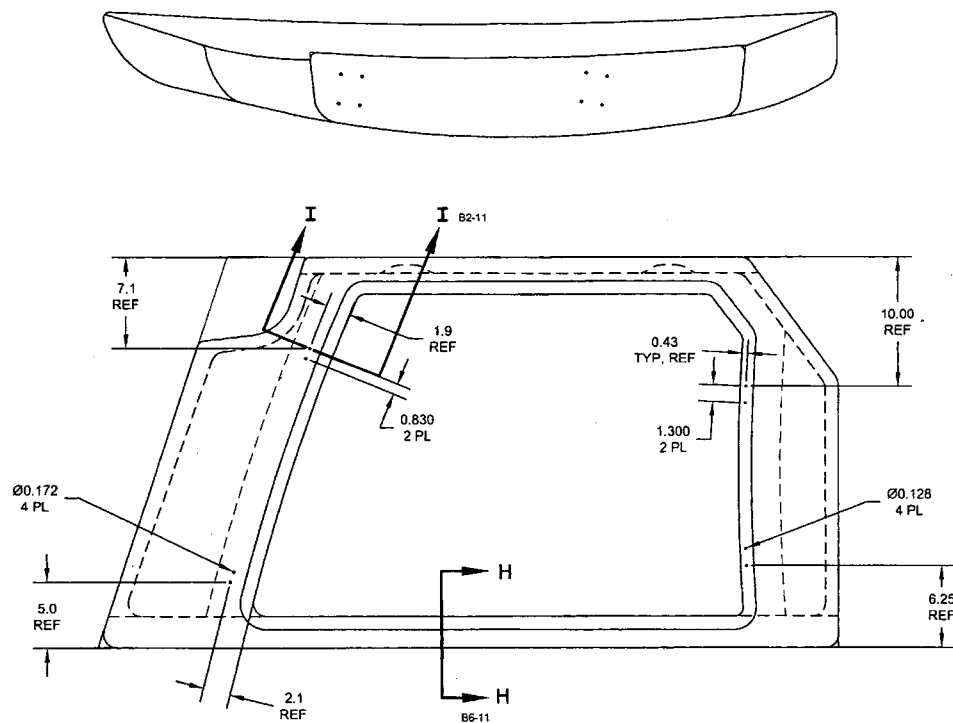
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

W10-64599

RELEASED
2009-10-20

| | | | |
|------------|---------------|--|---------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. F |
| MFG. APPR. | RF | D3188 | SHEET 5 OF 11 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | SPACEPOD BODY | NTS |
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D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

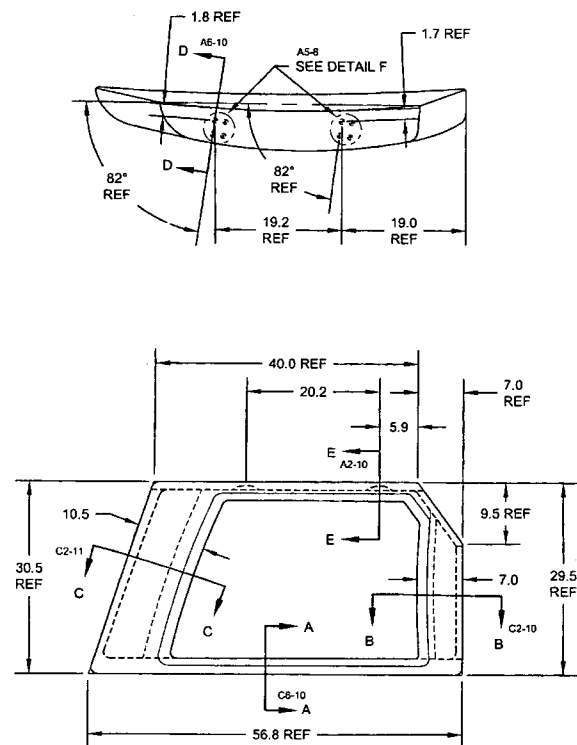
NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

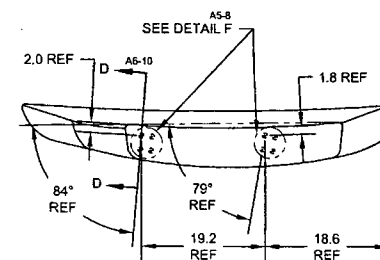
W10: 64599

RELEASED
2009-10-20
AM

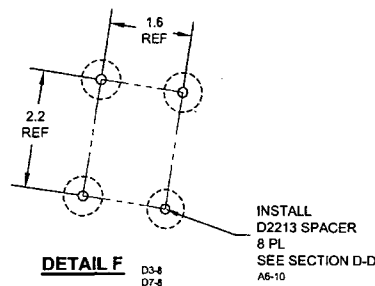
| | | | |
|------------|--------------------|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>[Signature]</i> | D3188 | SHEET 7 OF 11 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | SPACEPOD BODY | NTS |
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY







DETAIL F

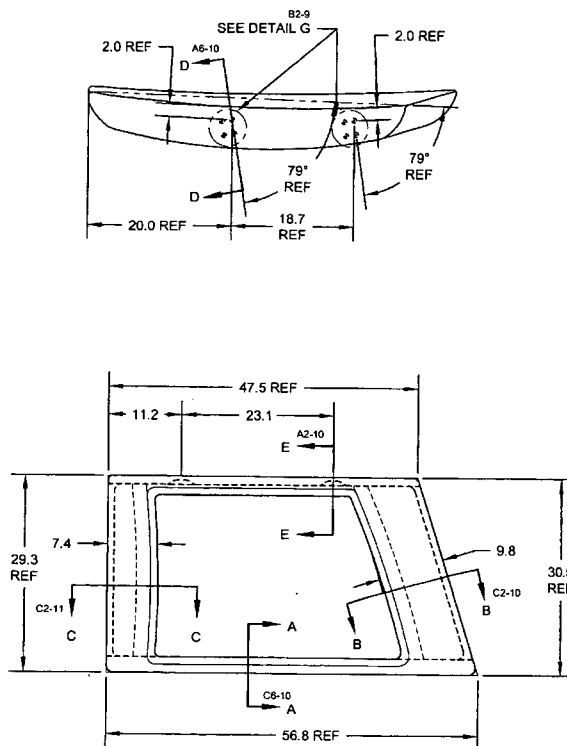
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

D3186-1M/-3M NOTES:

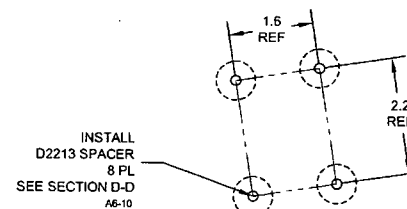
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2009-10-23

| | | | |
|---|---|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D3188 | SHEET 8 OF 11 |
| APPROVED |  | TITLE | SCALE |
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D3188-2M SPACEPOD BODY



DETAIL G D6-9

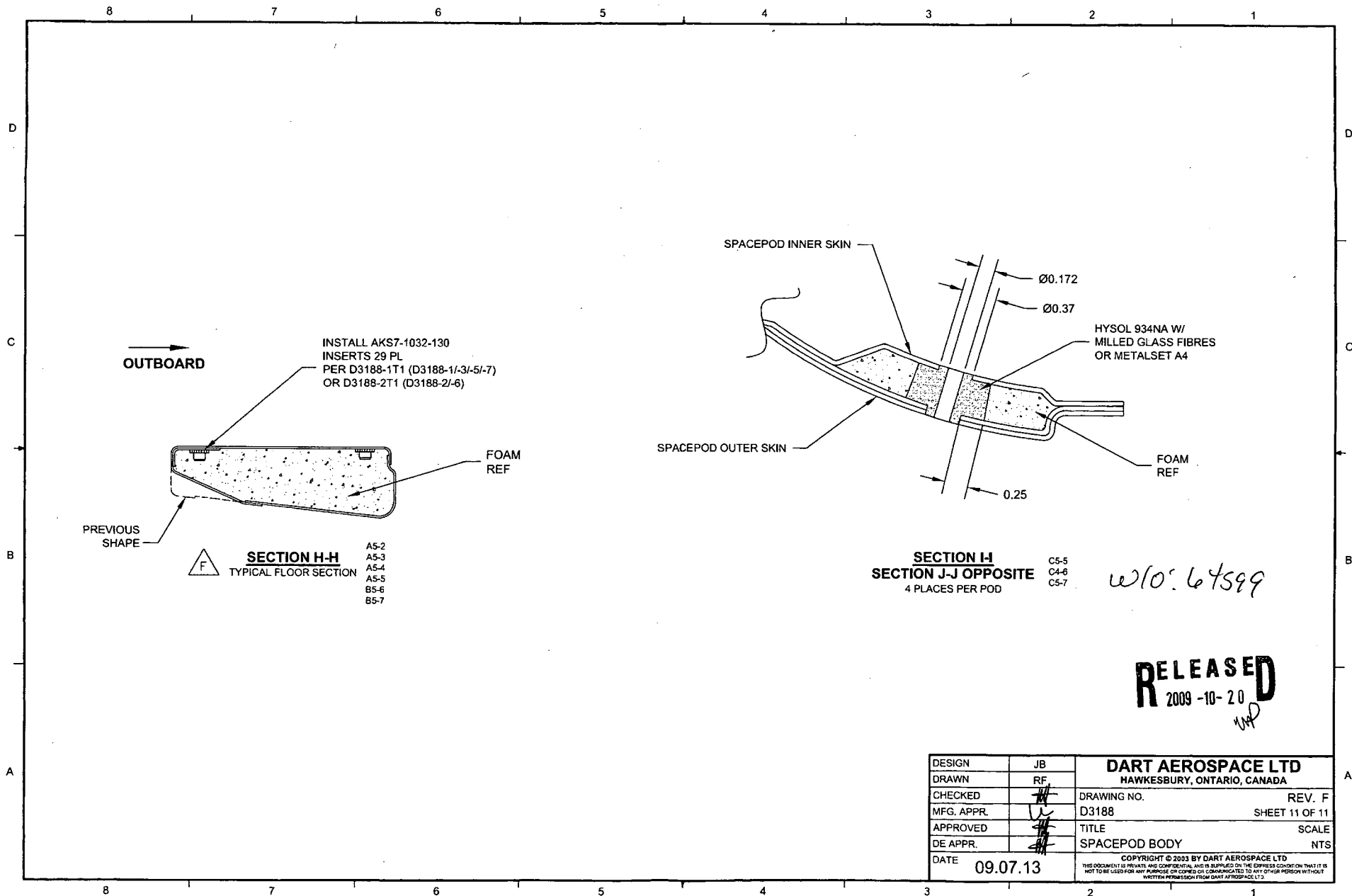
W10: 64599

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2009-10-20

D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

| | | | |
|------------|--------------------|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. F |
| MFG. APPR. | <i>[Signature]</i> | D3188 | SHEET 9 OF 11 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
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Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

| | |
|------------|---------|
| Invoice # | 36929 |
| Customer # | DART US |

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

| Ship via | | F.O.B. | | Terms | | Salesperson | |
|--------------|------------|---------------|----------------|--|--|--------------------------|--|
| Puro Collect | | Origin | | Net 30 days USA | | Claude Lessard, ext. 233 | |
| Ship date | Order Date | Our PO # | Order by | Your PO # | | GST/PST # | |
| 01/02/2011 | 09/12/2010 | 16263 | Chantal Lavoie | PO13107 | | | |
| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | | | |
| 1 | 0 | 1 | DKC134-0060 | Line 1 D31862P Spacepod Door RH B64598 U de M : Each Dwg. Rév.: E <div><div>No. série</div><div>No. lot</div><div>B64598</div><div>30722</div></div> | | | |
| 1 | 0 | 1 | DKC134-0071 | Line 2 D31882P, Spacepod Body RH (B64599) U de M : Each Dwg. D3188 Rév.: F <div><div>No. série</div><div>No. lot</div><div>B64599</div><div>30796</div></div> <div>Sulorla</div> | | | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2010-12-13 17:09:04
Utilisateur: Pascal Carignan

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 30796
Numéro Soumission : 3763
Numéro B.A. :
Cette fois : 2010-12-13 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 30740

Nom Dessin : SPACEPOD BODY RH
Numéro Article : DKC134-0071
Numéro Dessin : D3188
Projet Numéro : DK-362
Révision dessin : F
Matériel : Fibre 7781 et résine 411-350
Date Dûe : 2010-12-20 Qté: 1 Udm: UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D3188-2



B64599

Process Sheet Rév.: 02 ajout des nouveaux numéro d'IF/IG

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC


Commentair Qty.: 0.05 UNITE(s)/Unit Total : 0.05 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule selon IF134-0020.

Date: 15-12-10 Heure Début: — Heure Fin: — Sceau: 

3.0 AC0883 Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)

4.0 AC0884 Wrightlon 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-28776-2

8.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-22549-1

Date: Lundi, 2010-12-13 17:09:04
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30796

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

9.0

AMB0213

WR1850 Roving 18oz. x 50"

Commentair Qty.: 0.350 KILOGRAMME(s)/Unit Total: 0.350 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-22302-1

10.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 ROULEAU(s)/Unit Total: 4.0000 ROULEAU(s)

11.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 7-01-11 Heure Début: / Heure Fin: / Sceau:

12.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0640 GALLON(s)/Unit Total: 0.0640 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

13.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 LITRE(s)/Unit Total: 2.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-29325-1

14.0

AAC1540

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0040 GALLON(s)/Unit Total: 0.0040 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-7046-1

15.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 10/01/11 Heure Début: / Heure Fin: / Sceau:

16.0

AMB0355

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.750 FEUILLE(s)/Unit Total: 0.750 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick

N° de Lot: 1-6773-2

17.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 LITRE(s)/Unit Total: 0.200 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-29325-1

18.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0064 GALLON(s)/Unit Total: 0.0064 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

Date: Lundi, 2010-12-13 17:09:04

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30796

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

19.0

AAC1611

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)

Polybond B46F

N° de Lot:

1-26580-1

20.0

TAILLAGE

Faire le taillage du matériel



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

Tailler et ajuster les Foam Core selon IF134-0020.

Date: 17-1-11 Heure Début: _____ Heure Fin: _____ Sceau: _____



21.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-29325-1

22.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

23.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Sceller les foam core selon IF134-0020.

Date: 17-1-11 Sceau: _____ Initiales: _____



C.G.S.V.

24.0

PERCAGE

Perçage de trous



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Perçer les foam core selon IF134-0020.

Date: 18/01/11 Sceau: _____ Initiales: _____



C.G.S.V.

25.0

AAC1611

Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)

Polybond B46F

N° de Lot:

1-26580-1

26.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Installer les foam core selon IF134-0020.

Date: 18-1-11 Heure Début: _____ Heure Fin: _____ Sceau: _____



Date: Lundi, 2010-12-13 17:09:04
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30796

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.100 KIT(s)/Unit Total : 0.100 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-26644-1

28.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot:

29.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Usiner les foam core selon IF134-0020.

Date: 19-1-11

Heure Début:

Heure Fin:

Sceau:  

30.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-29325-1

31.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

32.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Laminer les plis de 9oz selon IF134-0020.

Date: 24/01/11

Heure Début:

Heure Fin:

Sceau:   

33.0

TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le taillage selon IF134-0022.

Date: 24/01/11

Heure Début:

Heure Fin:

Sceau: 

34.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

Date: Lundi, 2010-12-13 17:09:04

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30796

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

35.0

AAC1540

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot:

1-7046-1

36.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-29297-1

37.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 25/01/11

Heure Début: —

Heure Fin: —

Sceau:



38.0

AAC1610

Spacer N° D2213

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Spacer N° D2213

N° de Lot:

1-29400-1

39.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG0097.

Date: 25/01/11

Heure Début: —

Heure Fin: —

Sceau:



40.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)

Dupont Primer N° 7704S

N° de Lot:

1-28961-2

41.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot:

1-28382-1

42.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG0008.

Quantité: 1

Date: 26-01-11

Sceau:



Date: Lundi, 2010-12-13 17:09:04
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 30796

Numéro Article: DKC134-0071

Numéro Job:



Séq.:

Machine ou Opération:

Description :

43.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008 et la fiche technique.

Qté: 1 Date: 31-1- Sceau: D.A # de fiche de mélange: _____

44.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.020 KIT(s)/Unit Total : 0.020 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-26644-1

45.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.08 UNITE(s)/Unit Total : 0.08 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot: _____

46.0



FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG0008.

Date: 27/01/11 Heure Début: _____ Heure Fin: _____ Sceau:  

47.0


INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 12-01-11 Sceau:  Initiales: I.V

48.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage dans le contenant approprié.

Quantité: 1 Date: 1 fev 11 Sceau: LB

JOB 30796.